

What is claimed is:

1. A headliner assembly comprising;  
at least one core layer having upper and lower surfaces and formed of loosely intertangled polyester fibers; and  
a pair of bi-component layers formed of densely intertangled polyester fibers and attached to said respective upper and lower surfaces of said core layer.
2. A headliner assembly as set forth in claim 1 further including an outer covering layer attached to at least one of said bi-component layers.
3. A headliner assembly as set forth in claim 2 further including an upper bi-component layer attached to the upper surface of the core layer by a web adhesive and a lower bi-component layer attached to the lower surface of the core layer by a web adhesive.
4. A headliner assembly as set forth in claim 3 further including a pair of core layers interconnected by a web adhesive between said upper and lower bi-component layers.
5. A headliner assembly as set forth in claim 4 wherein said core layers and said bi-component layers include high melt fibers and low melt fibers.
6. A headliner assembly as set forth in claim 5 wherein said assembly is 100 percent recyclable.
7. A method a making a headliner assembly including the steps of:  
providing at least one core layer having upper and lower surfaces and formed of loosely intertangled polyester fibers;  
adhering an upper bi-component layer formed of densely intertangled polyester fibers to the upper surface of the core layer; and

adhering a lower bi-component layer formed of densely intertangled polyester fibers to the lower surface of the core layer.

8. A method as set forth in claim 7 further including adhering an outer covering to at least one of the bi-component layers.

9. A method as set forth in claim 8 further including the step of heating the core layer and bi-component layers prior to adhering the outer covering to one of the bi-component layers.

10. A method a making a headliner assembly including the steps of:  
providing at least one core layer having upper and lower surfaces and formed of loosely intertangled polyester fibers;

attaching an upper bi-component layer formed of densely intertangled polyester fibers to the upper surface of the core layer by intertangling fibers of the bi-component layer with fibers of the core layer; and

attaching a lower bi-component layer formed of densely intertangled polyester fibers to the lower surface of the core layer by intertangling fibers of the bi-component layer with fibers of the core layer.

11. A method as set forth in claim 10 further including adhering an outer covering to at least one of the bi-component layers.